Work Order January-08-14 12			*110)937*						Page 1
Revision ID:	3595-063-530 ubber Cushion		Accept	*N900	04 0	100)* s	etup Star	171	S1* S2*
Start Date: 1/	08/14 Start Qty: 20.00	*20*		Cust Item 1	D:					
Required Date: 1/	708/14 Req'd Qty: 20.00	*20*		Customer:						
Reference:						_	-	G.		
Approvals: 1	Process Plan: ML5	Date: 14-01-1 C	Tooling: _	D:	ate:		R	tun Sta	^I <i>V</i> I	R1*
	QC:			D:	ate:			Sto	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3595	Rev A									
100 *1 \\ Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as pe	er Dwg D3595	0.00				20	0		Jm14-02-21
reo 80 .	Dwg Rev:_ Prog Rev:_ 2-Deburr if	A								
110	QC2- Inspect parts off	machine FAI/FAIB	0.00							
110 QC Quality Control	Memo		0.00				20	_0		JM14-07-21
120	QC8- Inspect parts - sec	cond check	0.00				a -			1/11/20
120	Memo		0.00				20_			MW 1 14.06.64

Memo

Quality Control

DQA:			Date:										DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINS	ST DE	PARTMENT	/PROCESS	
, , , , , , , , , , , , , , , , , , ,	•				_	Rework	1		Skid-tube Crosstul	oe 🗀	1	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fa	ab 🗀	Pro	d. Eng. Coor.	Quality
:	•					Use-as-is		Therr	noforming Finishii	ng	Rec/Sto	re/Packaging	Other
NCR N	۱o. ِ					Suspected Unapproved]		Large Fab Composi	te]	Supplier	
Root				-	Desci	ription of work order update	1	nitial	Action	,	Sign &	!	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design							1						
Doc/Data	Щ	ı											
Equip/Tooling	Ц												
Handling/Pre	Н												
Material													
Operator													
Offset/Setup													
Process	H	:							į.				
Supplier													
Training Transport	H												
Unapproved													
опарртотеа	L		<u> </u>	1			FA	ULT CA	TEGORY		<u> </u>	<u> </u>	<u> </u>
Landi	ng (Gear				General							
		Bending				Bend		Folio/I	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	-		Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	α [Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
	L	Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	oe e		Fit/Function		Out of	Sequence				

Work Orde January-08-14				*110	1937*						Page 2
Item ID: Revision ID:	D3595-06	3-530		Accept	*N900	040	100)* s	Setup Star	*N	S1*
Item Name:	Rubber Cus	shion							Stop	*N	S2*
Start Date: Required Date: Reference:	1/08/14 1/08/14	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I	D:					• • •
Approvals:	Process 1	Plan:	Date:	Tooling:	D	ate:	-	F	Run Star	^I <i>V</i> I	R1*
••	QC:		Date:	_ SPC (Y/N):	D	ate:			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		Identify as per dwg & Sto	ock Location: Cross	0.00 حطر							Λ Λ
120 Packaging Packaging		Memo	Assi	0.00				20			<u>N'N114.0</u>
140		OCAL Final Language	Work Order Delega-	0.00							
*1 4 0		QC21- Final Inspection -	Work Order Release	0.00						140	2/24
QC		Memo		0.00					/4	11/00	<i></i>

Quality Control

PL14-02-24

DQA:		<u>.</u>	Date:											TRAC
OA Clasadi			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								AEROSPACE
QA Closed:			Date.								VOIK OIGC	.i up	date offiny	
Work Orde	er:					DISPOSITION				AGAINST [EPARTMI	ENT/	PROCESS	
	-				_	Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Prod. Eng. Coor.		I. Eng. Coor.	Quality
	•					Use-as-is			noforming	Finishing	Rec/		e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	
_	ī							••• •	I	· · · · · ·	- C:			
Root			<u>.</u> .	۵.	Desci	ription of work order update		nitial		tion	Sign	- 1	Manification	OC Inchestor
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	-	Verification	QC Inspector
Design	-						İ							
Doc/Data	\dashv								1					
Equip/Tooling	\dashv						İ							
Handling/Pre	-													
Material				<u> </u>										
Operator Offset/Setup	Н													
Process	H													
Supplier														;
Training					}									
Transport											İ			
Unapproved	П													
							FA	ULT CA	TEGORY					
Landi	ng (Gear				General		_						_
		Bending				Bend		Folio/F	Program		Outside	Dime	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		1	Over/U	nder 1	tolerance	Set-up
		Cracks				Broken/Damage/Defect	L	Hardwa	are	Ĺ	Part Inc			Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	L	Burrs	_	1	ion Incomplete/U		Part Los		ssing	Weld
l	L	Cuffs			_	Contamination		4	tions Incomplete/	F	Part Mo		L	Wrong Stock Pulled
		Crushing				Countersink	L	1	gned/off center	<u> </u>	Position		_	7
		Heat Trea				Cut Too Short		Mislabe		Į	Power l	.oss/S	Surge	Other
	_	Inspection		Tube	_	Drawing		Misrea						
		Marks/Ch				Drill Holes		Off-set						
]	<u> </u>	Turning S			<u> </u>	Finish	_	-1	Calibration					
Wave/Twist in Tube				Fit/Function	<u> </u>	Out of	Out of Sequence							

January-08-14 12:41:20 PM

Work Order ID:

110937

Parent Item:

D3595-063-530

Parent Item Name:

Rubber Cushion

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 07-08-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO80S.125		Purchased	No		,	100	sf	746.9344	0.0206	0.433684	_	. Tan	14-02-21
NEOPRENE SHEET 0.12	25	Purchased	NO			100	31	740.7544		<u> </u>	5	Jm	jŧ

Loc Code Location Loc Qty 746.9344 MAT052 131.1044 115916 94539 94539 615.83

DQA:			Date:										•	TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			–		AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		- 417
Work Orde						DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
WOIK OIGE	-					Rework	ı		Skid-tube Crosstube		1	Water Jet	\neg	Engineering
Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	┪	Quality
	-					Use-as-is		ľ	noforming Finishing		4	re/Packaging	┨	Other
NCR N	lo.		<u></u>			Suspected Unapproved			Large Fab Composite	′⊢	j '	Supplier		
Root					Desc	ription of work order update		nitial	Action		Sign &			
Cause		. Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design								•						
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material							ĺ							
Operator	_											İ	١	
Offset/Setup							l							
Process														
Supplier							İ						١	
Training													- 1	
Transport														
Unapproved												<u> </u>		
							FA	ULT CA	TEGORY					
Landi		!			_	General	_	1 ,	_		7	. г		_ /= /-
		Bending			<u> </u>	Bend	<u> </u>	1	Program	-	Outside Dim	-		Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	\vdash	Grain		<u> </u>	Over/Under	-	\dashv	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	\vdash	Hardwa		\vdash	Part Incorre		-	Temperature/Cure
	$\overline{}$	Crimp/Kii	nk/Ripple	/Wave	-	Burrs	<u> </u>	1 '	tion Incomplete/Unqualified	\vdash	Part Lost/Mi	-		Weld
		Cuffs				Contamination	\vdash	4	tions Incomplete/Unclear	-	Part Moved	-		Wrong Stock Pulled
	Н	Crushing			-	Countersink	_	4	gned/off center	-	Positioned V			Other
		Heat Trea		- 1	<u> </u>	Cut Too Short	\vdash	Mislab			Power Loss/	Surge [Other
	-	Inspectio	•	Tube		Drawing	\vdash	Misrea						
i.	<u> </u>	Marks/Ch				Drill Holes	\vdash	Off-set						
;	\vdash	Turning S	-		<u> </u>	Finish	_	4	Calibration		-			
l		Wave/Tw	vist in Tub	e	1	Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	110937
Description: Rubber Cushion	Part Number:	D3595-063-530
Inspection Dwg: D3595 Rev: A		Page 1 of 1

Inspection Dwg: I	D3595 Rev : A	4		<u>l</u>		Paç	je 1 of 1
	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	X	First Artic	ele	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
0.63	+/-0.030	0.63"			U	James	ľ
5.30	+/-0.030	5,30	_		U		
0.125	+/-0.010	0.125	-		<i>-</i>		
							
, - (ab) 4 li							

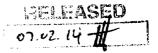
						<i>p</i> .	
			<u> </u>				
Measured by:	ton	Audited by:	who/		Prototype Ap	proval:	N/A
Date:	14-02-21	Date:	14.02	24		Date:	N/A
Rev Date	Change				Revise	d by	Approved

			·	
Rev	Date	Change	Revised by	Approved
Α	08.04.15	New Issue	KJ/DD KJ/DD	N
			-	

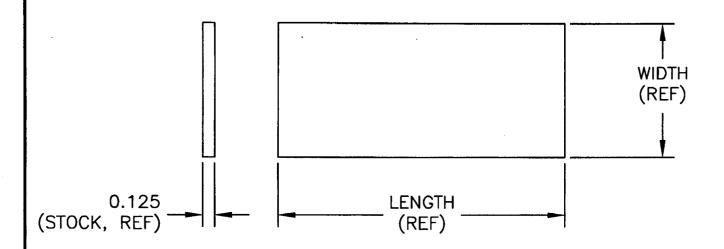
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DESIG	PH	DRAWN BY	DART AEROSP HAWKESBURY, ONTARI	
CHECH		APPROVED /	DRAWING NO.	REV. A
	-	1	D3595	SHEET 1 OF 1
DATE		·····	TITLE	SCALE
07.0	2.07		RUBBER CUSHION	NTS
Α		07.02.07	NEW ISSUE	



SPECIFICATION CONTROL DRAWING



SPECIFICATION: D3595-XXX-YYY RUBBER CUSHION

WIDTH LENGTH

EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

NOTES

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Mr214-01-10

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